

Work Order ID 56902

March 12, 2010 12:57:42 PM



Page 1

Item ID: D3781-043

Accept



Setup Start



Revision ID:

Item Name: Armrest Cushion Assembly

Stop



Start Date: 12/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

RP

Date: *10-3-12*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3781

D

100

0.00



Purchasing

Purchasing

Memo

0.00

Issue P/O: *11507*

Ship with D3785-1 SUPPORTING PLATE

Material: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT) AND COVER

D3781-5/D3785-1 ASSEMBLY WITH SURREY SILVER SUNSET

UPHOLSTERY FABRIC P/N SY-11. Zipper P/N: AI-Z021

THREAD: MIL-VT-295 TYPE2 CLASS A, GREY NYLON THREAD, 4-6

STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS.

Possible Supplier: AEROTEX INTERIORS INC.

Material release note is required

CY 10/3/15 8

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Packaging

Memo

0.00

PU 14/3/23 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56902

March 12, 2010 12:57:42 PM



Page 2

Item ID: D3781-043

Accept



Setup Start



Revision ID:

Item Name: Armrest Cushion Assembly

Stop



Start Date: 12/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00	8 10/03/29			✓ 8			
130 Packaging Packaging	Identify as per dwg & Stock Location: ST 180 185 Memo	0.00 0.00				CZ	10/3/31	(8)	
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/04/06 HJ PS 10-4-5 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

March 12, 2010 12:57:46 PM

Page 1

Work Order ID: 56902

Parent Item: D3781-043

Parent Item Name: Armrest Cushion Assembly

Comments: IPP RevA: New issue DD verified by:EC IPP Rev:B 09-05-15 As per ECN09-593P JLM Verified By:EC

Start Date: 12/03/2010

Required Date: 26/03/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3785-1		Manufactured	No			110	Each	5.0000	8.0000			

Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST088

5

55493

5

B 56669x8 CL10/31/6 ?

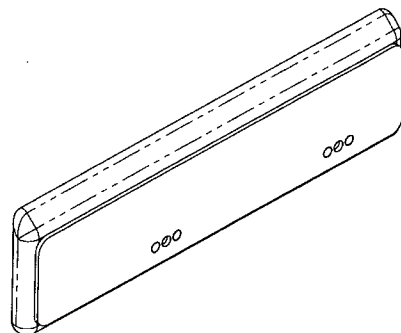
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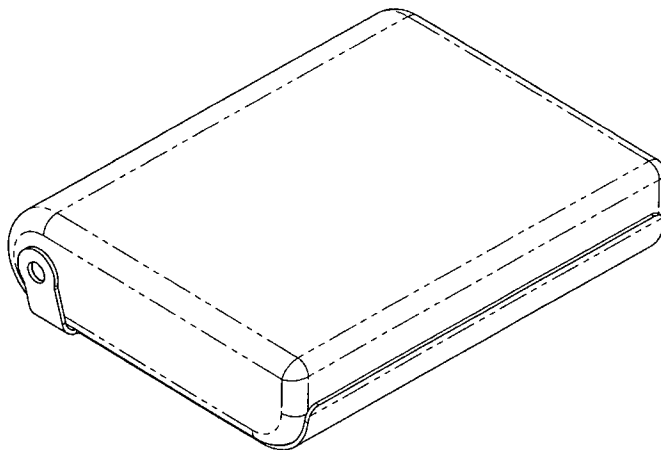
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3781-041 LATERAL CUSHION ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



D3781-043 ARMREST CUSHION
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

RELEASED
09/01/21 MB

56902

REV.	DESCRIPTION	BY	DATE
D	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.21
C	REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS	MB	08.11.10
B	REDESIGNED; ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
DESIGN			
DRAWN			
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3781** REV. D
TITLE **CUSHION ASSEMBLY** SCALE NTS
SHEET 1 OF 6

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

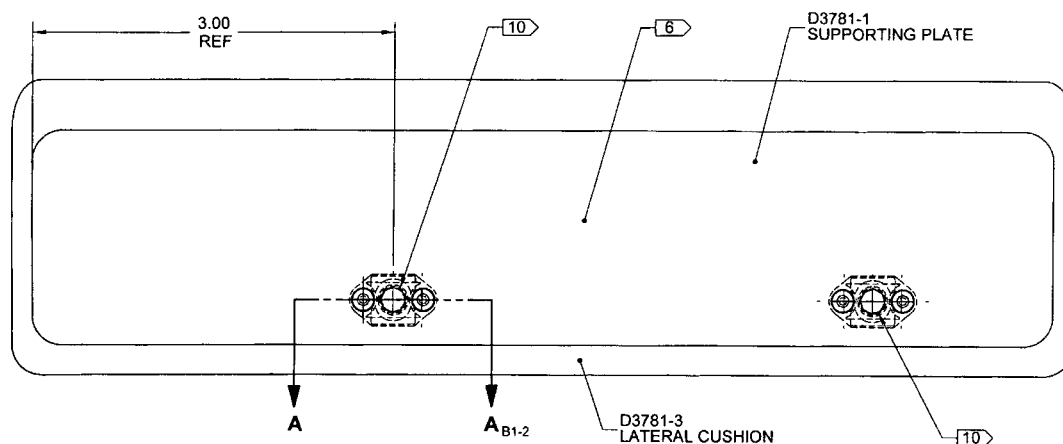
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

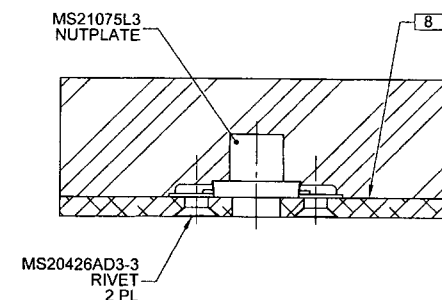
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
12	1	D3781-3	LATERAL CUSHION
22	2	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE
25	4	MS20426AD3-3	RIVET



D3781-041 LATERAL CUSHION ASSEMBLY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



SECTION A-A
2 PL, SCALE 2X

D3781-041 NOTES:

- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

RELEASED
09/07/21

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MFG. APPR.	AND	SHEET 2 OF 6
APPROVED		TITLE CUSHION ASSEMBLY SCALE NTS
DE APPR.		
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Dart Aerospace Ltd

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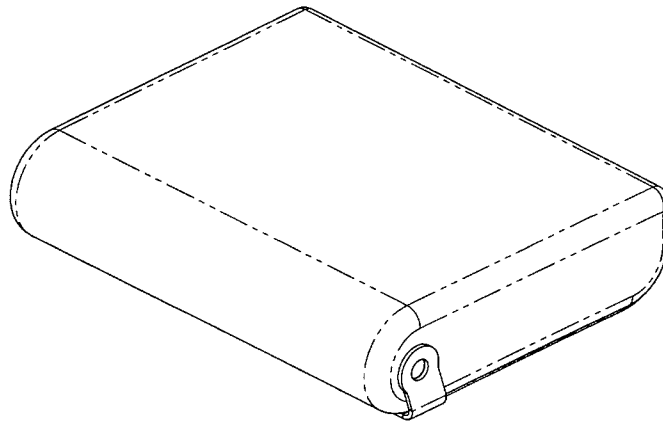
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

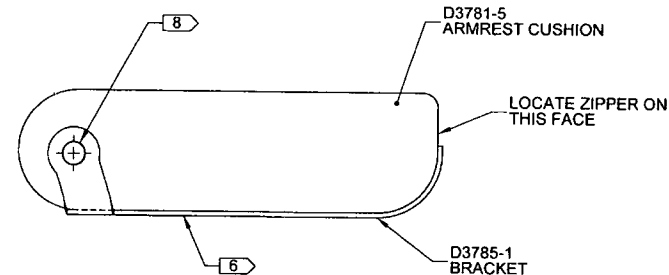
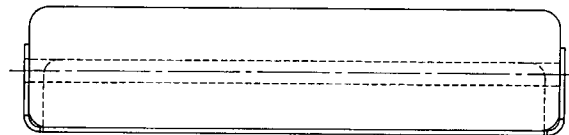
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3781-043	ARMREST CUSHION ASSEMBLY
11	1	D3785-1	BRACKET
12	1	D3781-5	ARMREST CUSHION
21	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
22	A/R	1300	3M SCOTCH-GRIP ADHESIVE



D3781-043 LATERAL ARMREST CUSHION BASE ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



D3781-043 NOTES:

- 1) MATERIAL: COVER D3781-5/D3785-1 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
ZIPPER P/N: AI-Z021
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-043" USING FINE POINT PERMANENT INK MARKER AFTER RECEIVING
- 7) WEIGHT: 1.14 lbs
- 8) DO NOT COVER HOLES WITH FABRIC

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MFG. APPR.	<i>[Signature]</i>	D3781	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CUSHION ASSEMBLY	NTS
DATE	09.05.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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09/07/21 *[Signature]*

56902

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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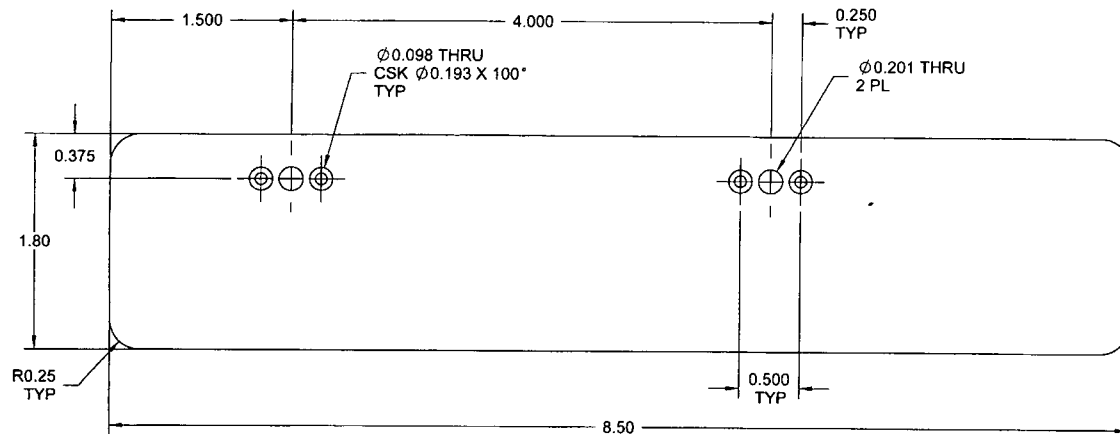
NOTE: Date & initial all entries

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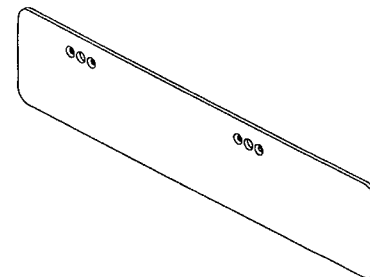
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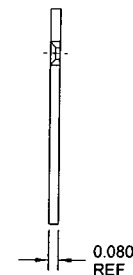
D3781-1 SUPPORTING PLATE



D

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B



56902

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09/07/14

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs

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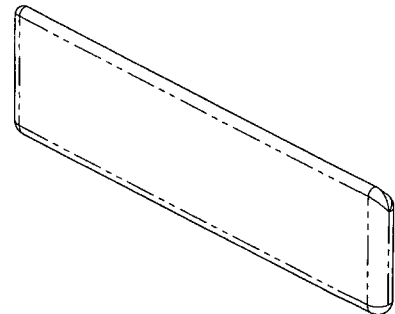
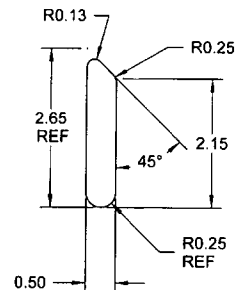
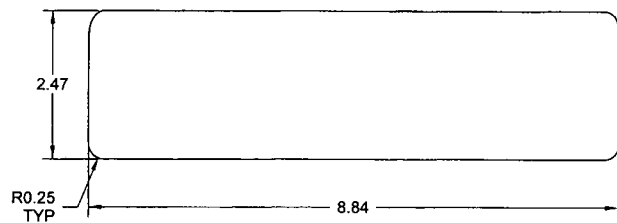
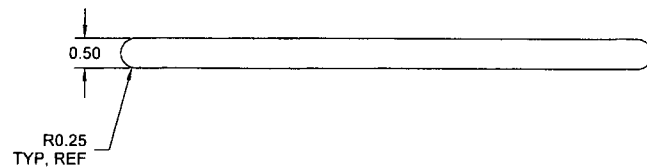
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NOTE: Date & initial all entries



D3781-3 LATERAL CUSHION

D3781-3 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

56902

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2/16/14

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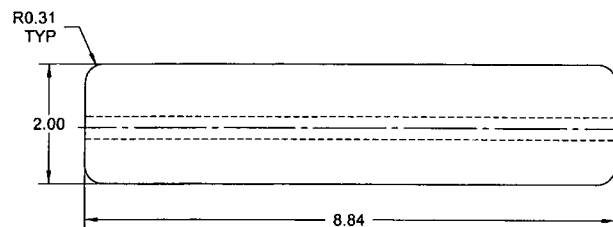
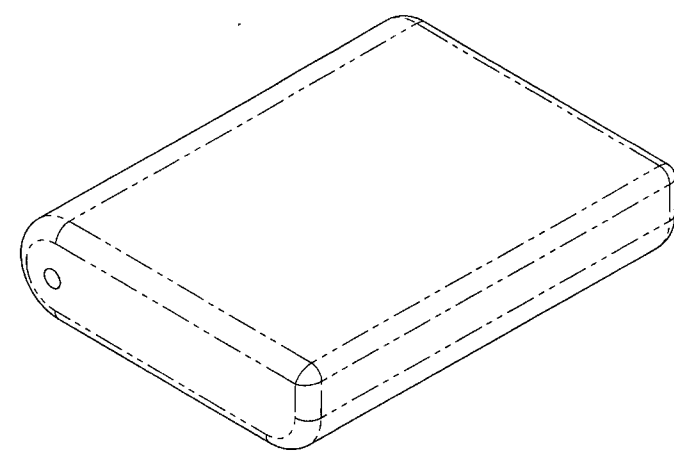
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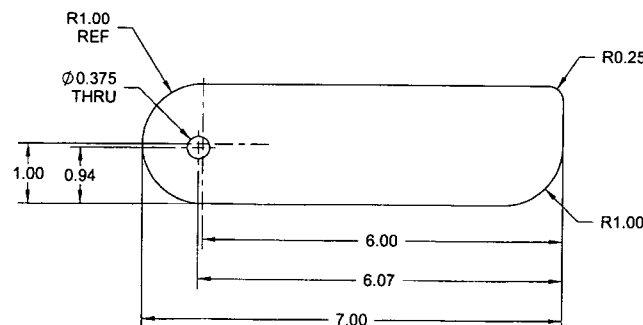
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D3781-5 ARMREST CUSHION



RELEASED

56902

D3781-5 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.67 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO11507**

Purchase Order Date 3/15/10

PO Print Date 3/15/10

Page Number 1 of 1

Order From :

VC-AER003

AEROTEX INTERIORS INC.
#24-2333 18TH AVENUE N. E.
CALGARY, AB T2E 8T6
CA

Contact Name
Vendor Phone 403 295 8770
Vendor Fax 403 313 0793
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	d3781-041P	Lateral cushion ass'y	3/23/10 Yes	6.00 Each	FedEx PI collect	\$175.0000	\$1,050.0

Special Inst: AS PER DWG D3781 REV. D
B56901
MATERIAL: SKANDIA HR150
POLYFOAM (4.6 LBS/CU FT) AND
COVERD37-1/-3 ASSEMBLY WITH
SILVER SUNSET UPHOLSTERY FABRIC
P/N: SY-11. BOND FABRIC USING 3M
1300/1300L ADHESIVE (0.002" TO 0.010"
THICK) IN ACCORDANCE WITH
MANUFACTURE INSTRUCTION
THREAD: MIL-VT-295 TYPE 2 CLASS A.
GREY NYLON THREAD, 4-6 STIRCHES
PER INCHS, USE MIN. BACKSTISCH. NO
LOOSE THREADS

2	D3781-043P	armrest cushion ass'y	3/23/10 Yes	✓ 8.00 Each	FedEx PI collect	\$175.0000	\$1,400.0
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CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Special Inst: AS PER DWG D3781 REV. D
B56902
MATERIAL SAME AS ABOVE

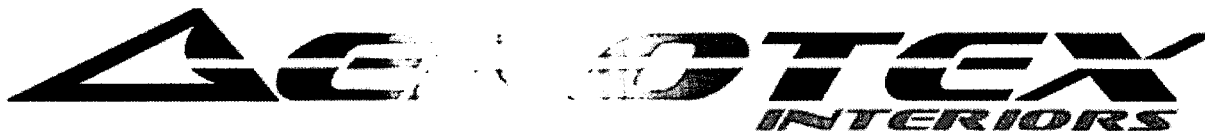
PO Total: \$2,450.0

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 3/15/10



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2A 8L6 - Phone: (403) 295 -8770 - Fax: (403) 313 - 0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order:
Our Work Order:

2011507
213

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

MATERIAL - SURREY SILVER S...

FOAM - HR150

THREAD - MIL-V-T-295, CLASS ...

HAS BEEN FABRICATED TO EST ... SPECIFICATION TO CONFIRM WITH
FAR 27.853(a), 29.853(a) and ... 756/D3755

SOLD TO:

DART AEROSPACE LTD., 1100 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295 -8770 - Fax: (403) 313 - 0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order:
Our Work Order:

PO11507
6221

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK
ORDER STATED ABOVE:

FOAM - HR150

THREAD - MIL-V-T-295, CLASS A, TYPE II

VINYL - SURREY SILVER

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH
FAR 27.853(a), 29.853(a) and DWG. D3781 Rev D

SOLD TO:

DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

A large, stylized handwritten signature in black ink, written over a horizontal line.